

ship 23/07 On Asset!

Work Order ID 87252

87252

Page 1

July-11-12 11:23:19 AM

Item ID: D412-761-041A

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Full Vertical Reference Door, LH

Start Date: 7/10/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: V Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9514	B
IIN D412-761	D

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D412-761-041A/ DSI9514 CHG001

0.00

110

0.00

110

Packaging

Packaging

Pick Kit

Memo

0.00

MLJ 12/07/12

12/7/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87252

87252

Page 2

July-11-12 11:23:19 AM

Item ID: D412-761-041A Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Vertical Reference Door, LH
 Start Date: 7/10/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		91 12/11/13					
130 *130* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-761-041A /DSI9514 Location: _____ PPP Rev: _____	0.00 0.00						12/13/13	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MLJ 12/07/16 MF 12-07-16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 11:23:19 AM

Page 1

Work Order ID: 87252

Parent Item: D412-761-041A

Start Date: 7/10/12







Required Date: 8/17/12

Parent Item Name: Full Vertical Reference Door, LH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D412-761-045 CH19001 Large Bubble Window, LH		Manufactured	No			110	Each	3.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG091		1							
				85300		1							
				FG110		2							
				81608		2							
 D412-761-047 CH19001 Door Mounted Instrument Panel		Manufactured	No			110	Each	3.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG031A		3							
				57755		3							
 D412-761-051 CH19002 Alternate Armrest		Manufactured	No			100	Each	0.0000		1			

B 8712954

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
X					D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	X	1			D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
1		X			D412-761-045	LARGE BUBBLE WINDOW KIT, LH
1			X		D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
1				X	D412-761-049	ARMREST KIT, LH
	1				D3589-041	LATCH ASSEMBLY
	1				D3589-047	FORWARD GUIDE
	1				D3589-049	AFT GUIDE
	2				MS16997-22	SCREW
	2				AN960JD6L	WASHER
	2				MS21042L06	NUT
		1			D3676-1	LARGE BUBBLE WINDOW
		1			D3678-1	PLACARD
		1			D3678-3	PLACARD
		1			D3700-1	INBOARD WINDOW DOUBLER
		1			D3700-3	OUTBOARD WINDOW DOUBLER
		1			D3701-1	FLOOR DOUBLER
		1			D3702-1	FORWARD DOUBLER
		1			D3703-1	AFT DOUBLER
		1			D3703-3	AFT CORNER DOUBLER
		1			D3703-5	AFT CAP
		1			D3704-1	ESCUTCHEON
		1			D3704-3	ESCUTCHEON
		1			D3708-1	ANGLE
		1			D3708-3	ANGLE
		1			D3709-1	ANGLE
		1			D3709-3	ANGLE
		1			D3802-1-135	SEAL
		1			DT9458	CUTTING TEMPLATE
	26				AN3-7A	BOLT
	52				AN960JD10	WASHER
	26				MS21042L3	NUT
	1				MS24694-C5	SCREW (OR MS24694-S5)
	1				MS24694-C13	SCREW (OR MS24694-S13)
			1		D3705-041	INSTRUMENT PANEL ASSEMBLY
			1		D3705-043	* INSTRUMENT PANEL WELDMENT
			1		D3335-1	* SPRING
			1		D3705-5	* ACCESS PANEL
			1		D3706-5	* PIN
			2		D3707-3	* MOUNTING LUG
			4		AN526C1032R6	* SCREW
			1		AN960JD516	* WASHER
			1		MS171498	* SPRING SLOTTED PIN
			4		MS24693-C272	* SCREW (OR MS24693-S272)

*DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 9)

(CONTINUED FROM PAGE 8)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
			2		D3707-1	MOUNTING LUG
			1		D3790-1	INDEXING BLOCK
			1		D3867-1	CONNECTOR PLATE
			4		AN3-3A	BOLT
			6		AN526C1032R6	SCREW
			2		AN743-12	BRACKET
			6		AN960JD10L	WASHER
			6		MS21075L3	NUTPLATE (OR MS21073-3)
			4		MS24693-C272	SCREW (OR MS24693-S272)
			1		MS27039-1-17	SCREW
			1		MS27039-1-27	SCREW
			4		MS21042L3	NUT
			2		MS21919WDG8	CLAMP
				1	D3694-041	MOUNTING PLATE ASSEMBLY
				1	D3694-1	* KEYWAY
				1	D3694-3	* PROTECTIVE PLATE
				1	D3694-5	* MOUNTING PLATE
				1	AN526C1032R8	* SCREW
				5	AN960JD10	* WASHER
				4	MS21042L3	* NUT
				2	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				1	MS24693-C271	* SCREW (OR MS24693-S271)
				4	MS24693-C273	* SCREW (OR MS24693-S273)
				1	D3695-041	SLIDER ASSEMBLY
				1	D3695-1	* SLIDER
				1	D3695-3	* STOPPER
				1	D3801-1	* HAND RETRACTABLE SPRING PLUNGER
				1	MS21209F6-25	* HELI-COIL, SCREW LOCKING (RED)
				4	MS21209F1-20	* HELI-COIL, SCREW LOCKING (RED)
				4	MS24693-C276	* SCREW (OR MS24693-S276)
				1	D3780-041	ARMREST ASSEMBLY
				1	D3696-041	* ARM ASSEMBLY
				1	D3696-1	** ARM
				1	D3801-3	** HAND RETRACTABLE SPRING PLUNGER
				1	D3781-041	* LATERAL CUSHION ASSEMBLY
				1	D3781-043	* ARMREST CUSHION ASSEMBLY
				1	D3785-3	* BRACKET
				1	D3977-1	* BOLT
				1	D3978-1	* NUT (CASTELLATED)
				1	D3979-1	* WASHER (SQUARE HOLE)
				2	AN970-6	* WASHER
				1	MS24665-302	* COTTER PIN
				2	MS21042L3	* NUT
				2	MS24693-C272	* SCREW
				2	MS24693-C277	* SCREW
				1	NAS1149D0663J	* WASHER

* DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

(CONTINUED ON PAGE 10)

• COPYRIGHT © 2008 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: D

Date: 09.06.18

(CONTINUED FROM PAGE 9)

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
				11	AN3-6A	BOLT
				1	AN6-26	BOLT
				1	AN310-6	CASTELLATED NUT
				11	AN960JD10	WASHER
				1	AN960JD616L	WASHER
				2	NAS1515H6L	WASHER
				1	MS24665-302	COTTER PIN
				3	MS21071L3	ANCHORNUT
				8	MS21075L3	NUTPLATE

6.0 PARTS LIST, OPTIONAL VENT KIT

QTY -141	PART NUMBER	DESCRIPTION
X	D412-761-141	VENT KIT
4	D3932-1	SNAP VENT

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-761 REV. D OR EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-761 REV. 1 OR EARLIER

REF. TCCA STC: SH09-4

REF. EASA STC: 10028917

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D412-761-011/-011A LH FULL VERTICAL REFERENCE DOOR KIT. THESE KITS CONSIST OF AN OEM LH DOOR MODIFIED BY DART PER INSTALLATION DRAWINGS D412-761-1 AND D412-761-049/-051 ARMREST KIT (NOT INSTALLED). A WIRING HARNESS MUST BE ORDERED SEPERATELY. AMEND THE PARTS LIST OF IIN-D412-761 REV. D AND ICA-D412-761 REV. 1 AS FOLLOWS:

5.0 PARTS LIST, FULL VERTICAL REFERENCE DOOR MOD (IIN-D412-761)

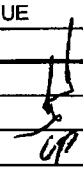
52.10 PARTS LIST (ICA-D412-761)

QTY -011	QTY -011A	QTY -041	QTY -041A	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -141	PART NUMBER	DESCRIPTION
X										D412-761-011	FULL VERTICAL REFERENCE DOOR, LH
	X									D412-761-011A	FULL VERTICAL REFERENCE DOOR, LH
1		X								D412-761-041	FULL VERTICAL REFERENCE DOOR KIT, LH
	1		X							D412-761-041A	FULL VERTICAL REFERENCE DOOR KIT, LH
				X	1					D412-761-043	MODIFIED LATCH MECHANISM KIT, LH
		1	1		X					D412-761-045	LARGE BUBBLE WINDOW KIT, LH
		1	1			X				D412-761-047	DOOR MOUNTED INSTRUMENT PANEL KIT, LH
		1					X			D412-761-049	ARMREST KIT, LH
			1					X		D412-761-051	ARMREST KIT, LH
1	1								X	D412-761-141	VENT KIT
1	1									204-030-853-125	BELL 204, 205, 210, 412 OEM DOOR (OR 204-030-853-137 OR 204-030-853-155 (BELL 212), OR 204-030-853-153 (BELL 214))

IN ALL OTHER RESPECTS, THE D412-761-011/-011A SHOULD BE INSTALLED ON THE AIRCRAFT PER SECTION 3.1 OF INSTALLATION INSTRUCTIONS IIN-D412-761; CRITICAL INSTRUMENTS SHOULD BE INSTALLED PER SECTION 3.2 OF INSTALLATION INSTRUCTIONS IIN-D412-761; THE D412-761-049/-051 ARMREST KIT SHOULD BE INSTALLED PER SECTION 3.3 OF INSTALLATION INSTRUCTIONS IIN-D412-761 AND DSI 9520 (FOR D412-761-051). MAINTAIN THE D412-761-011/-011A KIT PER INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-761.

THE WEIGHT AND BALANCE FOR D412-761-011 IS SAME AS D412-761-041.
THE WEIGHT AND BALANCE FOR D412-761-011A IS SAME AS D412-761-041A.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED  BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>10.05.12</u> CERT. NO.: <u>SH09-4</u> ISSUE NO.: <u>2</u>

B	ADDED D412-761-011A	MB	10.05.12
A	NEW ISSUE	MB	10.04.12
REV.	DESCRIPTION	BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B	
DRAWN		SHEET 1 OF 1	
CHECKED		DRAWING NO. DSI 9514	
MFG. APPR.		TITLE	
APPROVED		FULL VERTICAL REFERENCE DOOR	
DE APPR.		SCALE NTS	
DATE	10.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	